

Work Order ID 80897

80897

Page 1

March-05-12 9:20:33 AM

Item ID: D4021-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Data Plate
 Start Date: 05/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/05 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4021	B

100		0.00							
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100 Ac 12.03.20 (X12)

Shear Memo 0.00

Shear 1-Cut as per dwg D4021

2- break sharp corner as per dwg D4021

3-Deburr as required

QC5- Inspect part completeness to step on W/O

120 0.00

120 5/2/03/76

QC Memo 0.00

Quality Control

12 12 22

W/O: 80897		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D40213 PAR #: _____ Fault Category: Large PAB NCR: Yes No DQA: Atk Date: 12/04/04
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 12/4/4

NCR:		WORK ORDER NON-CONFORMANCE (NCR) $3.82 \times 12 = 45.84$						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
# 12/03/22	# 100	Qty + 12 (all) Parb cut too short. should be 4.42" meaning 4.00". L.C. envelope READ wrong Part of the Day. LQA	S 11/13/22 052042	Scrap, Destroy + Replace B 120604 Scrap + Destroy + Replace	At 12.22.03	WJ 12 03 22	S 12/03/22 052042	S 12/09/22

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80897***80897***

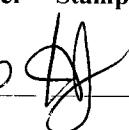
Page 3

March-05-12 9:20:33 AM

Item ID: D4021-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Data Plate
Start Date: 05/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 09/03/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/3/30 
CL 12/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-05-12 9:20:38 AM

Page 1

Work Order ID: 80897

80897

Parent Item: D4021-3

D4021-3

Parent Item Name: Data Plate

Start Date: 05/03/2012

Required Date: 09/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC
 new part DD 09.12.03 verified by:EC
 REV.A DD 10.02.22 verified by:EC
 10.04.20 verified by:EC
 IPP RevB:
 IPP Rev:C as per dwg
 IPP Rev:D as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

217.5165

0.1944

1.227789

M304S20GA

304/316 .040 Sheet

**

Ac 12.03.20
 12.03.23

Location

Loc Qty

Loc Code

MAT020

217.5165

116623

0.2

117933

27.3442

118400

21.1723

118964

36.5

119346

29.8

120604

102.5

*Scrapped
 2.455578
 of MATERIAL

~~2.455578~~
 4.911156

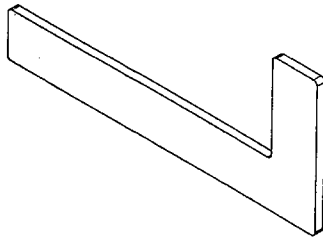
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

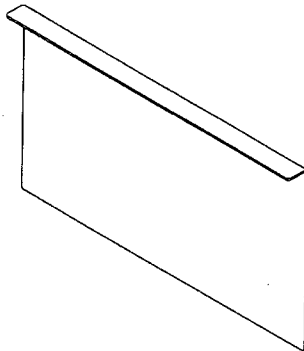
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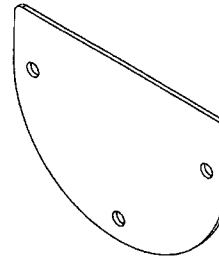
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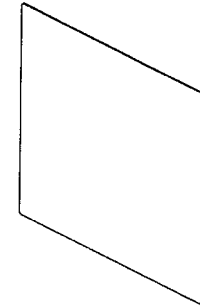
D4021-1 HANDLE PLATE



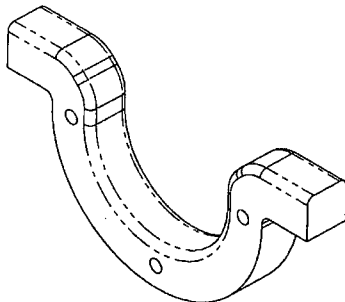
D4021-3 DATA PLATE



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



D4021-9 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80897 MLCJ

12/03/05

RELEASED
2010-04-14
MJP

B	POWDER COAT SPEC ADDED TO NOTE 2 (A&2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4021	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

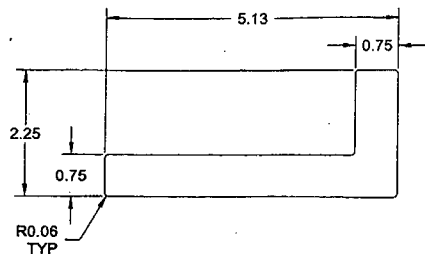
Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

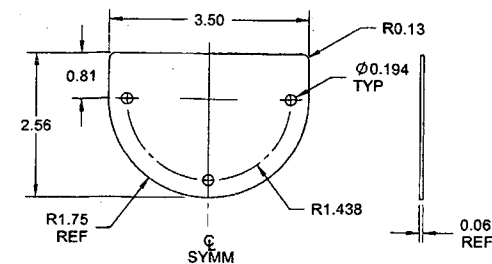
NOTE: Date & initial all entries



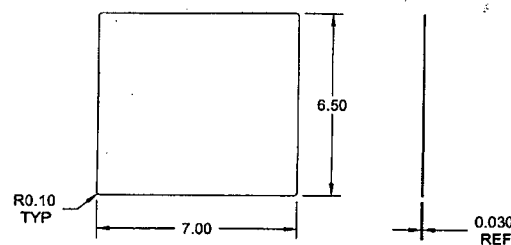
D4021-1 HANDLE PLATE



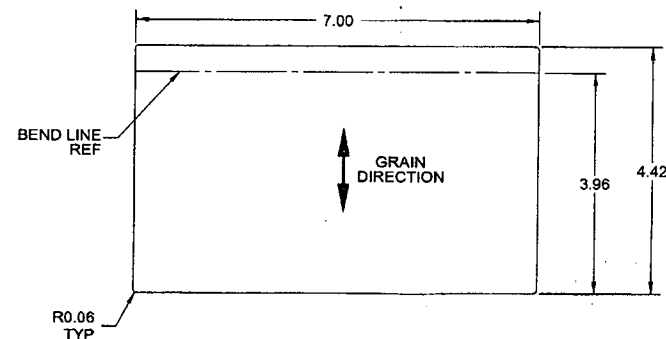
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE





D4021-3F DATA PLATE
FLAT PATTERN

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH: -1/-3/-11: NONE
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs
-5: 0.14 lbs -11: 0.39 lbs

RELEASED
R 2010-04-14
NP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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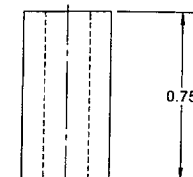
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4021-9 BUSHING

22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4021 TITLE MISC PARTS - 350 BASKET SCALE NTS
DRAWN	JPH	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
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